

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023281**Date Inspected:** 05-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

Trial Assembly / OBG segment 12CW

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as OBG 12CW welds as per ZPMC notification # 09035.

The weld designations reviewed are as follows:

LD3023-001-058, 059, 092, 093
SEG3006B-136, 137

Trial Assembly / OBG Lift 13 East

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as OBG lift 13 East welds as per ZPMC notification # 09037.

The weld designations reviewed are as follows:

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

SA3060-009-001, 002, 003, 005, 007, 008
SA3060-010-001, 002, 003, 005, 007, 008
SA7009-001-001, 002, 003, 005, 007, 008
SA3060-001-001, 002, 003, 005, 007, 008
SA3060-002-001, 002, 003, 005, 007, 008
SA3060-003-001, 002, 003, 005, 007, 008

Trial Assembly / OBG segment 13AE-13BE

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 1G position of bottom panel weld # OBE13B-002. The welder is identified as 050242. Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS- B-T-2231-ESAB.

Trial Assembly / OBG segment 13AE-13BE

This QA Inspector observed the following work in progress:

Sub Arc Welding (SAW) in the 1G position of Deck Panel weld # OBE13-002. The welder is identified as 058100. Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U2-S-4.

Trial Assembly / OBG segment 13AE-13BE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 1G position of Deck Panel weld # OBE13-002. The welder is identified as 044772. Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-B-U2-FCM-1.

Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey (+86) 15000026784 , who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
